

Page 1

Accept

1. The first step in the process is to identify the problem or issue that needs to be addressed. This involves gathering information and understanding the context of the problem.

2. Once the problem is identified, the next step is to define the objectives and goals of the project. This helps to clarify what needs to be achieved and provides a clear direction for the team.

3. The third step is to develop a plan or strategy to address the problem. This involves breaking down the problem into smaller, manageable tasks and determining the resources needed to complete each task.

4. The fourth step is to implement the plan. This involves putting the strategy into action and monitoring progress regularly to ensure that the project is on track.

5. The final step is to evaluate the results of the project. This involves comparing the actual outcomes against the objectives and goals to determine the effectiveness of the project.

Setup Start

[REDACTED]

Stop



(b) (7)(C), (b) (7)(D)

Cust Item ID:[illegible]

Customer:

Reference:

Run Start

Abstract

RF

Tooling:

Date:

Stop



QC:

Date:

SPC (Y/N):

Date:[illegible]
$$h = 6.750^u$$
$$L^0 \approx 13^0$$

8 10/09/28

④

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____






NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			



NOTE: Date & initial all entries




Work Order ID 61663

Tuesday, August 31, 2010 10:42:53 AM

Page 2

Item ID: D3391-021 Accept  Setup Start 
Revision ID: Stop 
Item Name: Fwd Tube Assembly
Start Date: 8/31/2010 Start Qty: 1.00  Cust Item ID:
Required Date: 9/7/2010 Req'd Qty: 1.00  Customer:
Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start 
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop 

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130  HAAS 1	HAAS CNC VERTICAL MACHINING #1	0.00				/			
HAAS CNC vertical machine #1	Memo 1-Machine as per Folio FA590 Rev. _____ & Dwg D3391 Rev. _____ Identify as D3391-1 2-Deburr <i>SA 10/11/15</i>	0.00							
140  QC	QC2- Inspect parts off machine FAI/FAIB	0.00				/			
Quality Control	Memo <i>SA 10/11/15</i>	0.00							
150  Mill Conv	CONVENTIONAL MILLING MACHINE	0.00							
Conventional Milling Machine	Memo Drill X1 Aft cap as per Dwg D3391 .1875" dia <i>SA 10/11/17</i>	0.00							

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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Work Order ID 61663

Tuesday, August 31, 2010 10:42:53 AM

Page 3

Item ID: D3391-021

Accept

Setup Start

Revision ID:

Stop

Item Name: Fwd Tube Assembly

Start Date: 8/31/2010 Start Qty: 1.00

Cust Item ID:

Required Date: 9/7/2010 Req'd Qty: 1.00

Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Run Start

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID Tool # Plan

Code

Accept
QtyReject
QtyReject
NumberInsp.
Stamp

160

QC2- Inspect parts off machine FAI/FAIB

0.00

10/11/17
S.A. 10/11/22

1

0

QC

Memo

0.00

Quality Control

170

QC8- Inspect parts - second check

0.00

10/11/22
S.A.

1

0

QC

Memo

0.00

Quality Control

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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Work Order ID 61663

Page 4

Tuesday, August 31, 2010 10:42:53 AM

Item ID: D3391-021

Accept



Setup Start



Revision ID:

Stop



Item Name: Fwd Tube Assembly

Start Date: 8/31/2010 Start Qty: 1.00



Cust Item ID:

Required Date: 9/7/2010 Req'd Qty: 1.00



Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

180



Skidtubes

Skidtubes

Memo

0.00

Skidtubes

1-Drill float bag holes as per Dwg D3391 using DT8798(Do not open tow cap holes to finish size)
(ONLY DRILL HOLES MARKED "A")

2-Drill Remaining two holes for tow cap using DT 8819 Locating off of .1875" holes drilled in previous step

3-Open tow cap holes to .208" as per Dwg D3391

4-Open Tow Ring hole to .640" as per Dwg D3391

5- open float bag holes 0.328" and counter sink as per dwg D3391

6-Deburr & Scribe Batch number Inside aft end.

7-Transfer drill D3391-021 with D3391-023



10-12-1

190



QC

Quality Control

QC5- Inspect part completeness to step on W/O

0.00

Memo

0.00

8/31/2010



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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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Work Order ID 61663

Tuesday, August 31, 2010 10:42:53 AM



Page 5

Item ID: D3391-021

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Setup Start



Revision ID:

Stop



Item Name: Fwd Tube Assembly

Start Date: 8/31/2010 Start Qty: 1.00



Cust Item ID:

Required Date: 9/7/2010 Req'd Qty: 1.00

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

200

Chemical Conversion Coat per QSI005 4.1

0.00



HandFinish

Memo

0.00

Hand Finishing

210

QC3- Inspect Part Finish

0.00



QC

Memo

0.00

Quality Control

220

Skidtubes

0.00



Skidtubes

Memo

0.00

Skidtubes

1-instal spacers as per dwg D3391
A/R Magnabond 6398 batch: M115580
exp. date: 07-2011
cure time 12hrs. as per QSI015
2- grind crossbolt flush
3-back drill crossbolt if necessary

DP

10-12-6

W/O:		WORK ORDER CHANGES					
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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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Work Order ID 61663

Tuesday, August 31, 2010 10:42:53 AM



Page 6

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Start Date:	8/31/2010	Start Qty:	1.00			
Required Date:	9/7/2010	Req'd Qty:	1.00			
Reference:						

Approvals:	Process Plan:	Date:	Tooling:	Date:	Run	Start	
	QC:	Date:	SPC (Y/N):	Date:		Stop	

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
230 QC Quality Control	QC5- Inspect part completeness to step on W/O Memo	0.00 0.00							
235 HandFinish Hand Finishing	Pressure Wash per QSI005 4.3 Memo AND REALODINE AS PER PAR09-043	0.00 0.00		10/12/13		1	2		
240 Powdercoat Powder Coating	White Gloss(Ref:4.3.5.1) per QSI005 4.3-Alum Memo START TIME: 1:50 OVEN TEMPERATURE: 320° FINISH TIME: 2:20	0.00 0.00				1			BL 10-12-15

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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Work Order ID 61663

Tuesday, August 31, 2010 10:42:53 AM



Page 8

Item ID: D3391-021

Accept



Setup Start



Revision ID:

Stop



Item Name: Fwd Tube Assembly

Start Date: 8/31/2010 Start Qty: 1.00



Cust Item ID:

Required Date: 9/7/2010 Req'd Qty: 1.00



Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
260 	Identify as per dwg & Stock Location: _____	0.00		10/12/17		1	9		
Packaging	Memo	0.00							
Packaging									
280 	QC21- Final Inspection - Work Order Release	0.00							
QC	Memo	0.00							
Quality Control									

10/12/2010

MF
10-12-16

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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Picklist Print

Tuesday, August 31, 2010 10:43:14 AM

Page 1

Work Order ID: 61663

Parent Item: D3391-021

Parent Item Name: Fwd Tube Assembly



Start Date: 8/31/2010

Required Date: 9/7/2010

Start Qty: 1.00

Required Qty: 1.00

Comments: IPP A 05.09.13 New issue KJ/JLM
 IPP B 06.02.10 Dwg rev.D ecn 773 EC
 IPP C 06.05.02 Added inspections EC
 IPP D 07.03.13 rev F dwg EC
 IPP E 07.11.07 revG dwg ecn1053P EC verified by: DD
 IPP Rev:f ECN 1056 07-11-12 DD verified by: EC
 IPP Rev:G 08-09-08 new process (ecn 08-510) DD verified by:EC
 IPP Rev:H 08-09-10 revH as per dwg DD verified by:EC
 IPP Rev J 09.02.02 added hardware EC verified by: DD

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	-------------	--------------	---------------	----------------	--------

D6013-047		Manufactured	No			100	Each	39.0000	1	1			
-----------	--	--------------	----	--	--	-----	------	---------	---	---	--	--	--

Skidtube Material

Location Loc Qty Loc Code

LG 39

23935 3

26547 36

D3670-4-200		Manufactured	No			220	Each	64.0000	4	4			
-------------	--	--------------	----	--	--	-----	------	---------	---	---	--	--	--



SPACER

Location Loc Qty Loc Code

LG 64

57349 64

D3401-041		Manufactured	No			255	Each	12.0000	1	1			
-----------	--	--------------	----	--	--	-----	------	---------	---	---	--	--	--



Tow Cap Assembly

Location Loc Qty Loc Code

FP 12

46029 12

DP 10-9-27

DP 10-12-6
 10/12/17

XI

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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Picklist Print

Tuesday, August 31, 2010 10:43:14 AM

Page 2

Work Order ID: 61663

Parent Item: D3391-021



Parent Item Name: Fwd Tube Assembly

Start Date: 8/31/2010

Required Date: 9/7/2010

Start Qty: 1.00

Required Qty: 1.00

D3564-13 Manufactured No 255 Each 19.0000 1 1

 Wearshoe  HL 10/12/16

Location

Loc Qty

Loc Code

FP17

19

~~B6882~~ *



X1

59660

7

60862

12

D3566-13 Manufactured No 255 Each 22.0000 1 1

 Gasket  HL 10/12/16

Location

Loc Qty

Loc Code

FP012

22



59661

14

60209

8

X1

AN960C10L NAS1149C0332 Purchased No 255 Each 155.0000 10 10

 washer  HL 10/12/16

Location

Loc Qty

Loc Code

ST245

155

M15832

X10

107534

29

109545

54

111548

72

Tuesday, August 31, 2010 10:43:14 AM

Shop Packet Print

Page 2

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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Picklist Print

Tuesday, August 31, 2010 10:43:14 AM

Page 3

Work Order ID: 61663

Parent Item: D3391-021

Parent Item Name: Fwd Tube Assembly

Start Date: 8/31/2010

Required Date: 9/7/2010

Start Qty: 1.00

Required Qty: 1.00

AN3C4A Purchased No 255 Each 1,567.000 10 10
BOLT

Location

Loc Qty

Loc Code

ST303

500

M115936

X10

115438

500

ST350

1067

114108

14

114416

12

114523

2

114941

39

115300

1000

D3672-1 Manufactured No 255 Each 917.0000 4 4
Phenolic Washer

Location

Loc Qty

Loc Code

ST077

917

42329

150

52505

767

AEELS-1032-130 Purchased ~~No~~ 255 Each 0.0000 2 2
INSERT

AEELS-1032-225 Purchased ~~No~~ 255 Each 0.0000 10 10
INSERT

Tuesday, August 31, 2010 10:43:14 AM

Shop Packet Print

Page 3

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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Dart Aerospace Ltd

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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
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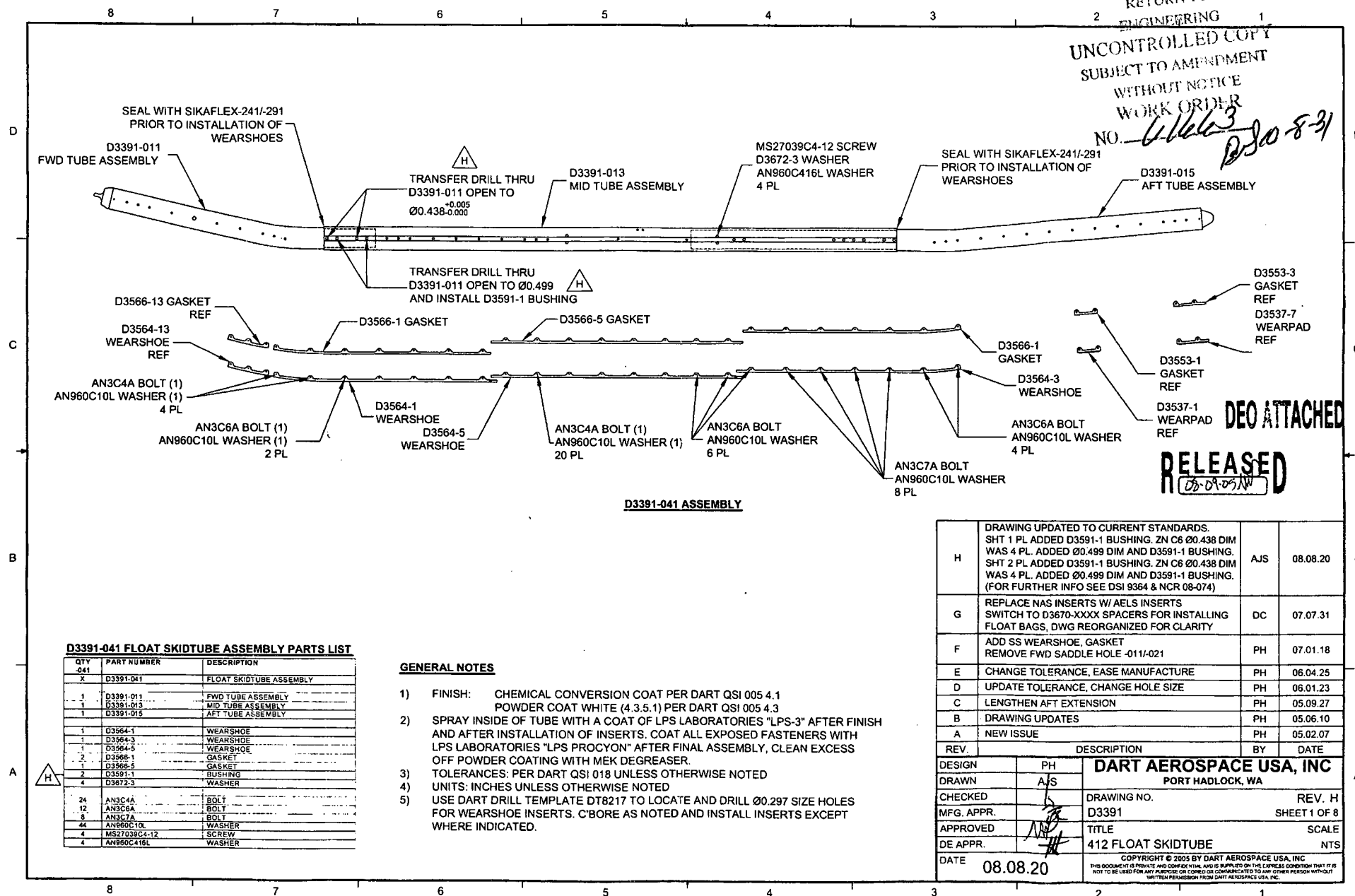
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SHOP COPY

RETURN TO
ENGINEERINGUNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICEWORK ORDER
NO. 64663

D80-8-31



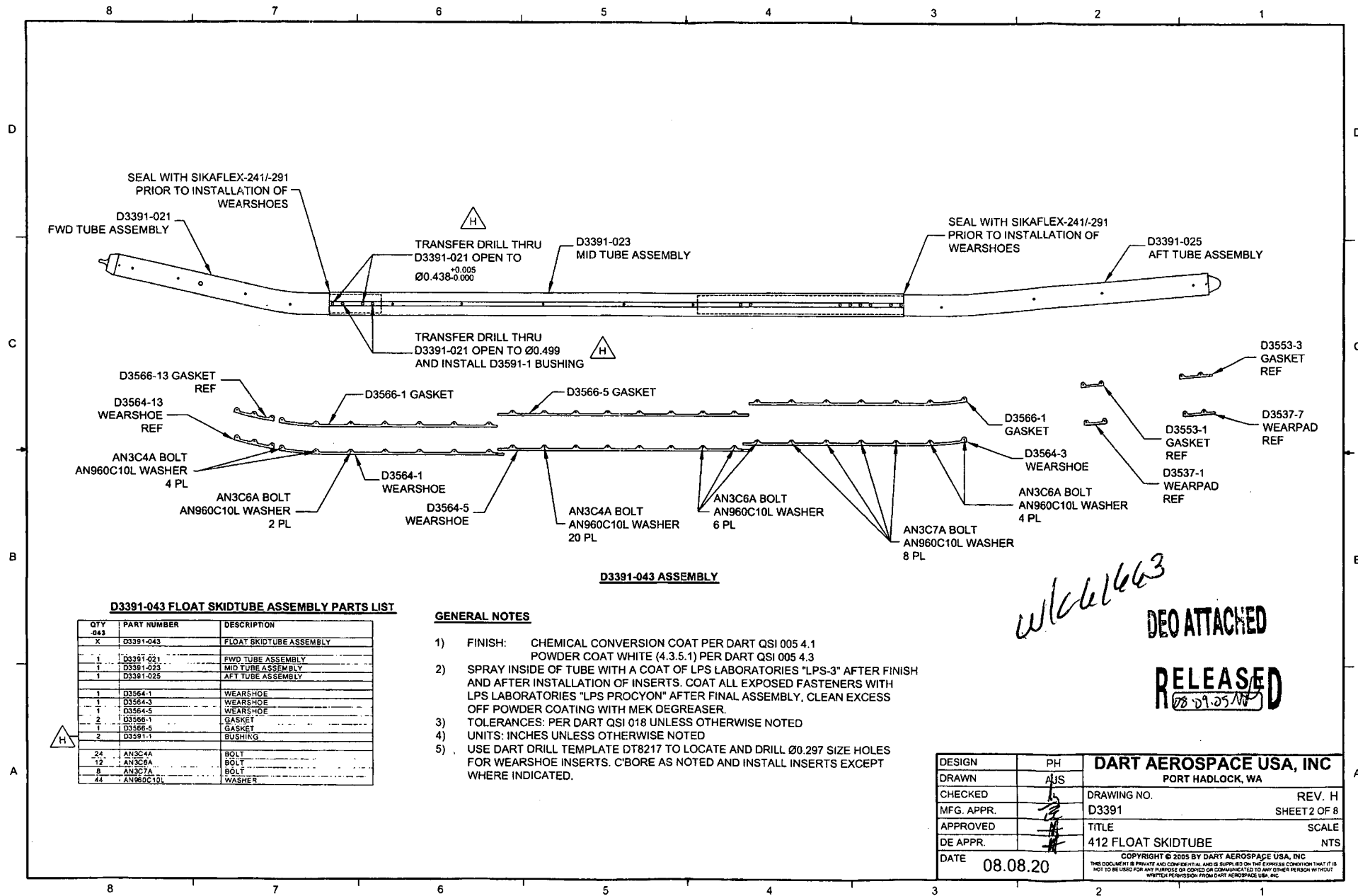
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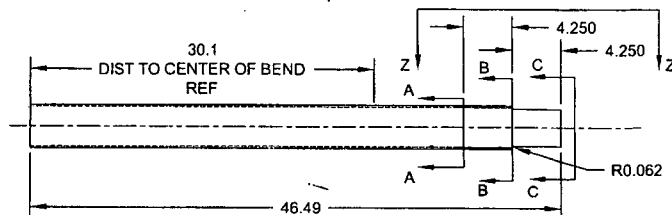
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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

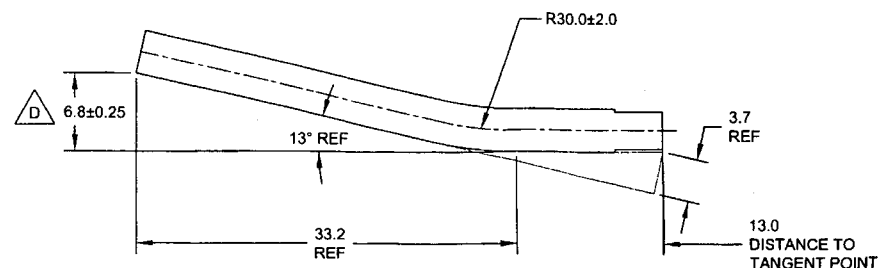
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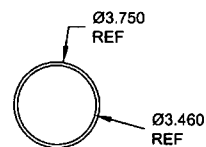
NOTE: Date & initial all entries



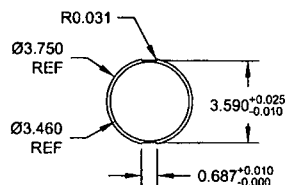
D3391-1 CUTTING DETAIL
(MAKE FROM D6013-047 SKIDTUBE MATERIAL)



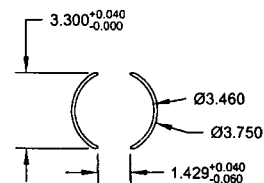
D3391-011/-021 BENDING DETAIL
(MAKE FROM D3391-1)



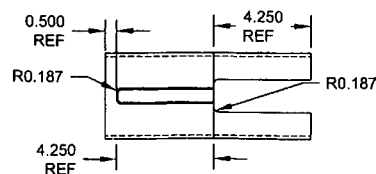
SECTION A-A
SCALE 2X



SECTION B-B
SCALE 2X



SECTION C-C
SCALE 2X



VIEW Z-Z
SCALE 2X

wlo 66663

DEO ATTACHED
RELEASED
08-05-11

DESIGN	PH	DART AEROSPACE USA, INC	
DRAWN	AJS	PORT HADLOCK, WA	
CHECKED	J	DRAWING NO.	REV. H
MFG. APPR.	W	D3391	SHEET 3 OF 8
APPROVED	JAN	TITLE	SCALE
DE APPR.	#	412 FLOAT SKIDTUBE	NTS
DATE	08.08.20	<small>COPYRIGHT © 2005 BY DART AEROSPACE USA, INC THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS ORCHON THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE USA, INC</small>	

0580
215

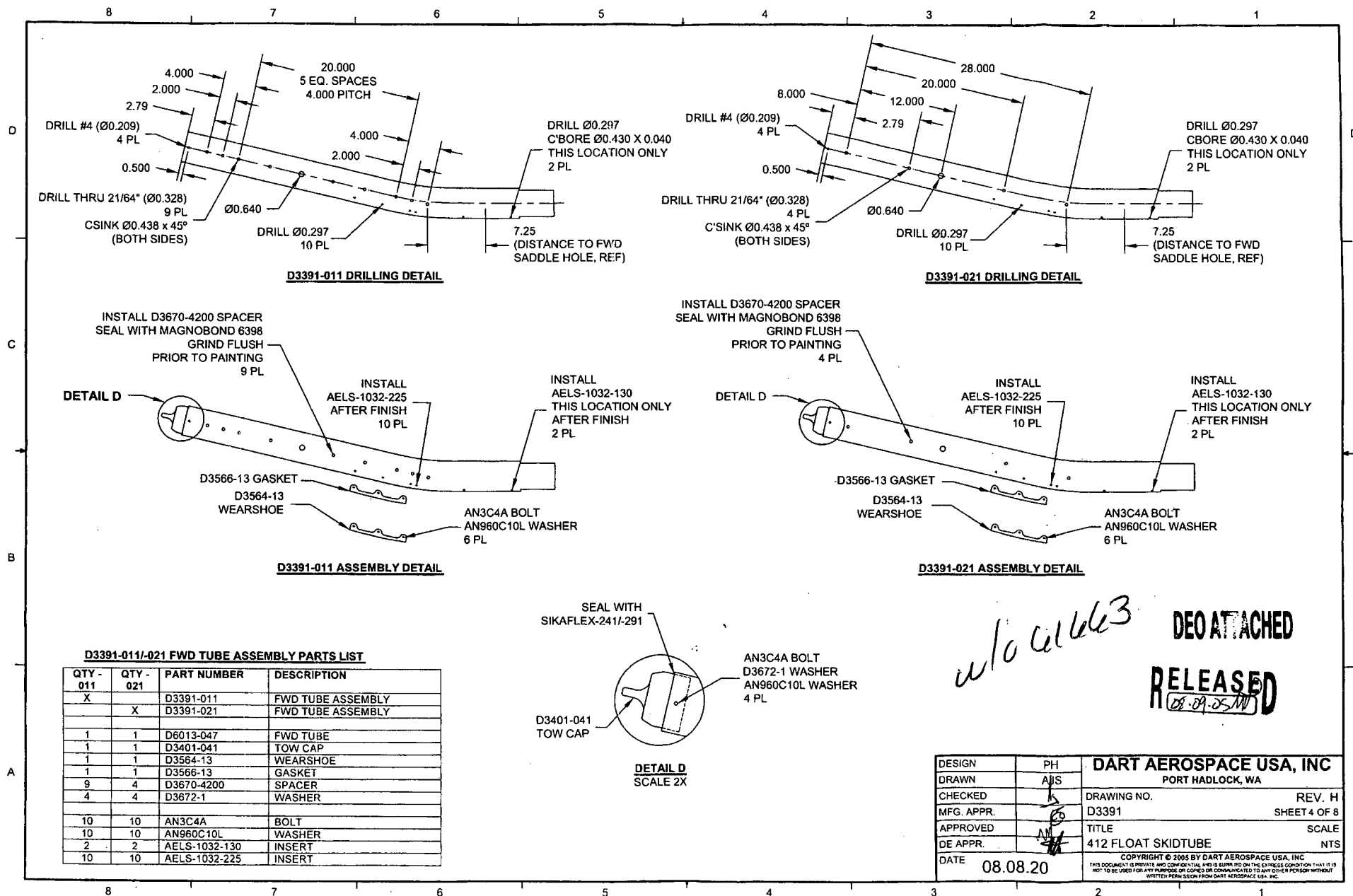
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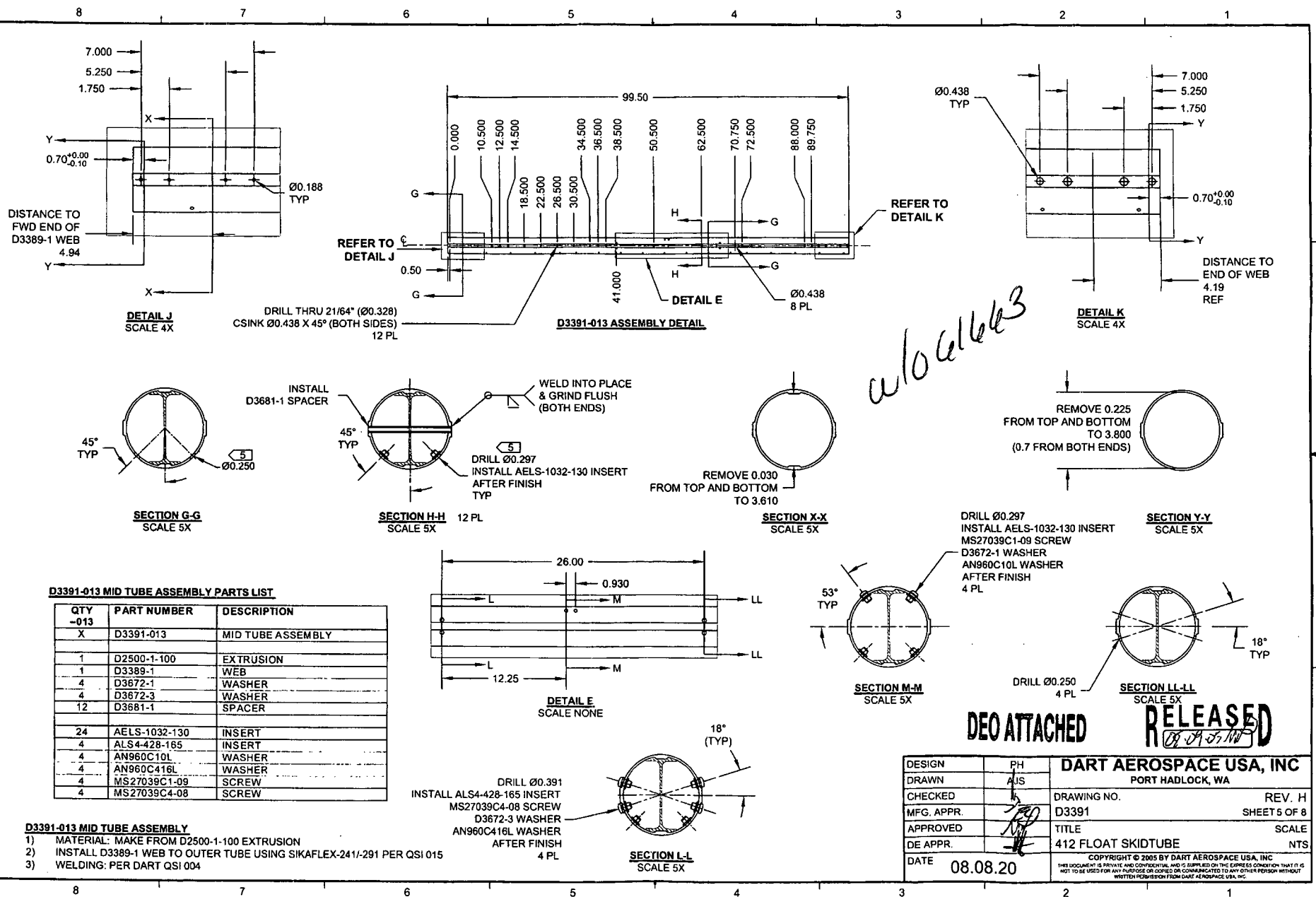
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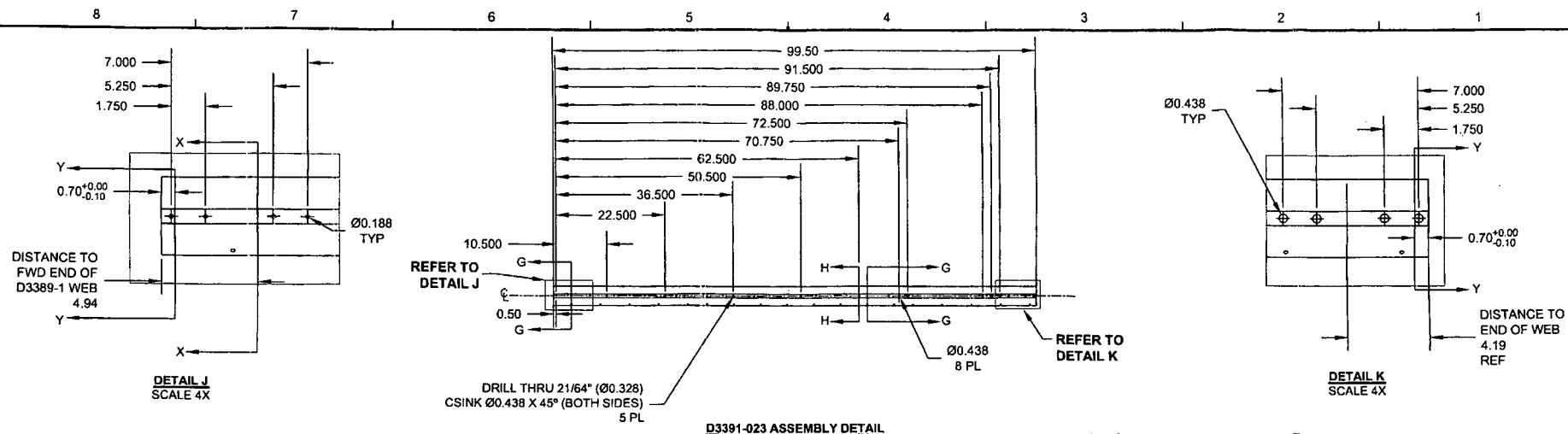
W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

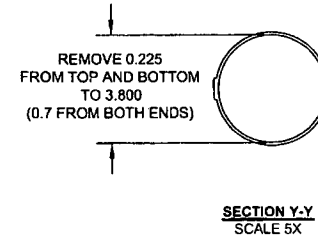
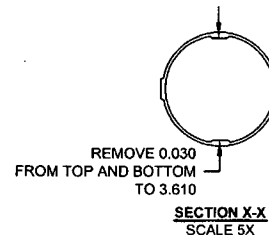
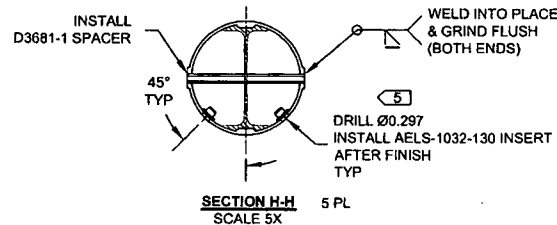
Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



w/o 6663



D3391-023 MID TUBE ASSEMBLY PARTS LIST

QTY -	PART NUMBER	DESCRIPTION
023		
X	D3391-023	MID TUBE ASSEMBLY
1	D2500-1-100	EXTRUSION
1	D3389-1	WEB
5	D3681-1	SPACER
20	AELS-1032-130	INSERT

D3391-023 MID TUBE ASSEMBLY

- 1) MATERIAL: MAKE FROM D2500-1-100 EXTRUSION
- 2) INSTALL D3389-1 WEB TO OUTER TUBE USING SIKAFLEX-241/-291 PER QSI 015
- 3) WELDING: PER DART QSI 004

DEO ATTACHED

RELEASED
08-09-05 JW

DESIGN	PH	DART AEROSPACE USA, INC	
DRAWN	AS	PORT HADLOCK, WA	
CHECKED	AS	DRAWING NO.	REV. H
MFG. APPR.	AS	D3391	SHEET 6 OF 8
APPROVED	AS	TITLE	SCALE
DE APPR.	AS	412 FLOAT SKIDTUBE	NTS
DATE	08.08.20	COPYRIGHT © 2005 BY DART AEROSPACE USA, INC THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE USA, INC.	

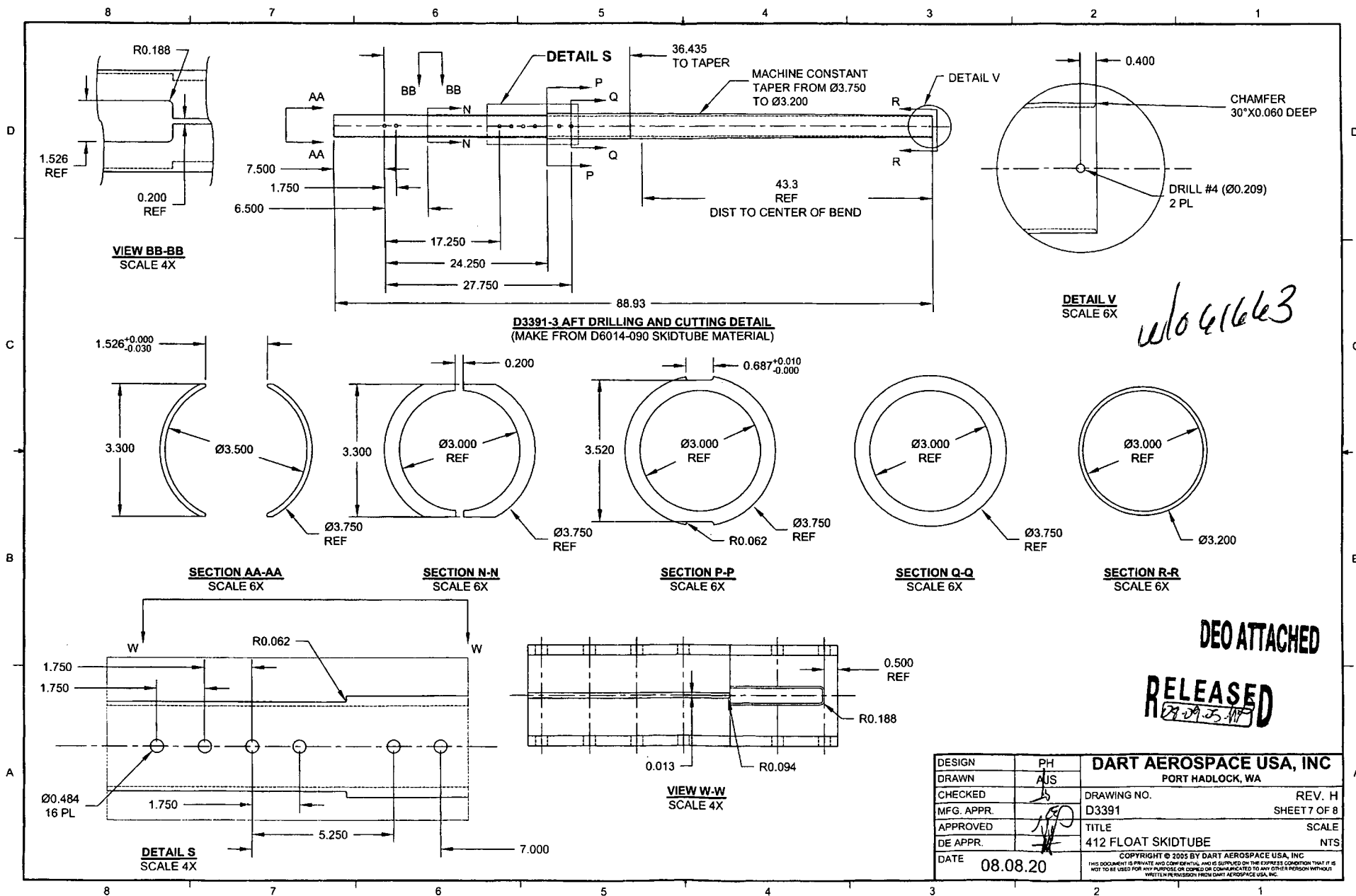
W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

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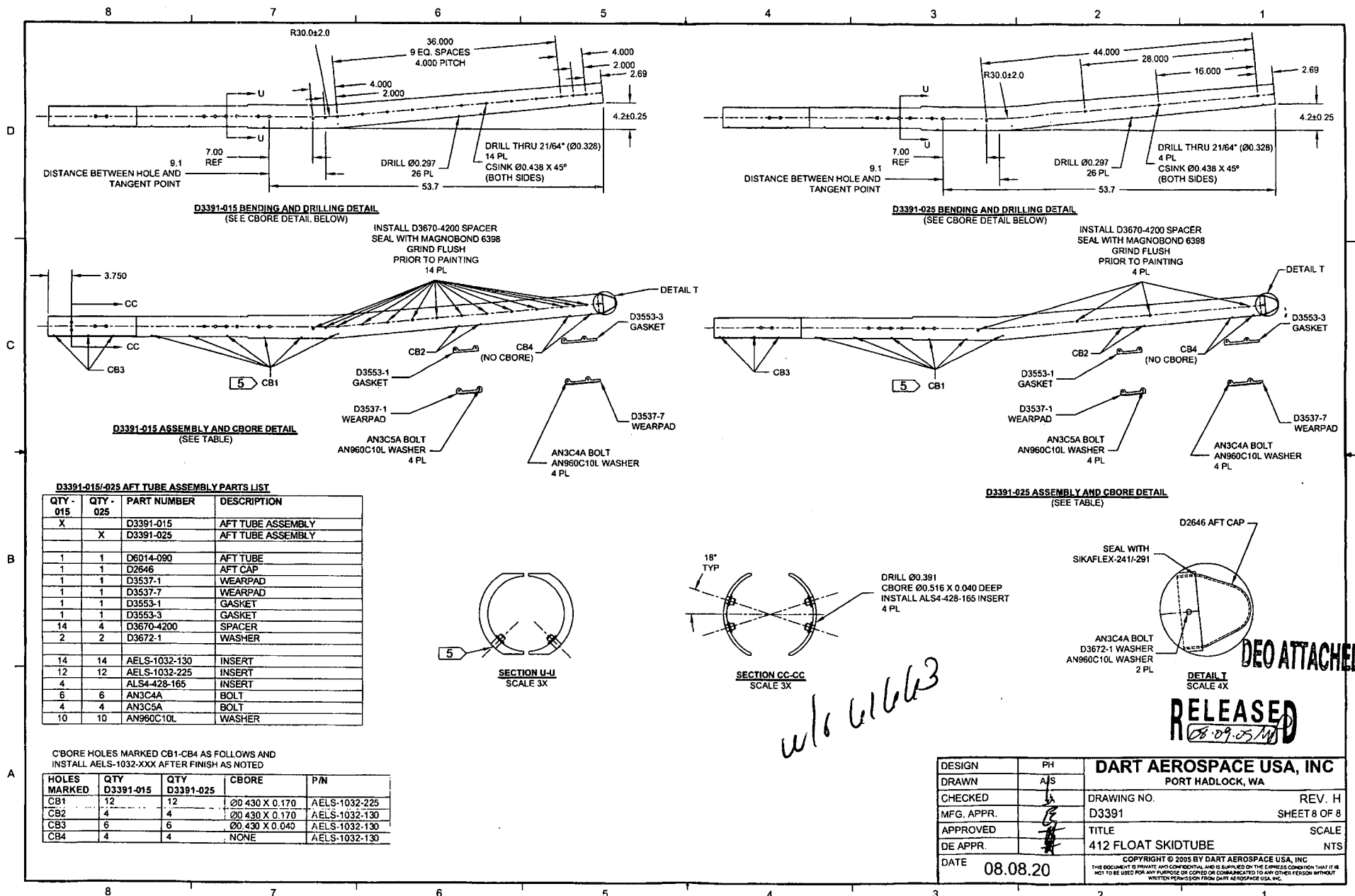
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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DRAWING NO. D3391	TITLE 412 FLOAT SKIDTUBE	REV. H	DART AEROSPACE USA, INC ENGINEERING ORDER		D.E.O. NO. D3391-H-1	SHEET NO. SHEET 1 OF 1	SCALE NTS
DRAWN <i>UP</i>	CHECKED <i>h</i>	MFG. APPR. <i>AA</i>	APPROVED <i>MP</i>		DE APPR. <i>h</i>		
DATE 09.09.23	DATE 04.04.24	DATE 09/09/25	DATE 09/09/30		DATE 09/09/30		

PURPOSE:

LPS-3 IS NO LONGER USED DURING ASSEMBLY OF D3391-041/-043 SKIDTUBES.

CHANGE:

AMEND NOTE 2 OF D3391-041/-043 SKIDTUBE ASSEMBLIES (ZN A6-1, A6-2) AS FOLLOWS:

- 2) ~~SPRAY INSIDE OF TUBE WITH A COAT OF LPS LABORATORIES "LPS-3" AFTER FINISH~~
~~AND AFTER INSTALLATION OF INSERTS.~~ COAT ALL EXPOSED FASTENERS WITH
 LPS LABORATORIES "LPS PROCYON" AFTER FINAL ASSEMBLY, CLEAN EXCESS
 OFF POWDER COATING WITH MEK DEGREASER.

RELEASED
 2010-02-02

MP

w/061663

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